

Date: Tuesday, 4/24/2007 3:14:56 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 32032D		
Estimate Number	: 10380		
P.O. Number	: <u>NIA</u>	Part Number	: D30657
This Issue	: 4/24/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D3065 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31794D	Material	: <u>NIA</u>
Written By	:	Due Date	: 5/20/2007 Qty: 60 Um: Each
Checked & Approved By	: <u>07.04.25</u>		
Comment	: Est:C 02/11/01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch: M104025

SAD 07/05/26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3065
Dwg Rev: 3
Prog Rev: 3

SAD 07/05/26 60

(70)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/26 60

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/06/26 60

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 07.06.03 60

(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-7 PAR #: N/A Fault Category: Prod - Smoked, WTS NCR ☒ Yes ☐ No DQA: AS Date: 07/02/20
 QA: N/C Closed: AS Date: 07/02/23

NCR: <u>32032D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	2.7	Scrap One part because of Machine offset "holes were to big"	<u>AS</u> 05/04/24	Scrap destroy and replace same B/N	SAD 07/15/26	<u>AS</u> 07/07/23	<u>AS</u> 05/04/24	<u>AS</u> 07/07/23

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:14:56 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 32032D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description:



6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 07/07/17 (60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/18 (X60)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SB 07-07-18 (X60)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 07/07/19 (60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/07/19 (60)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19

Job Completion



11 07-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

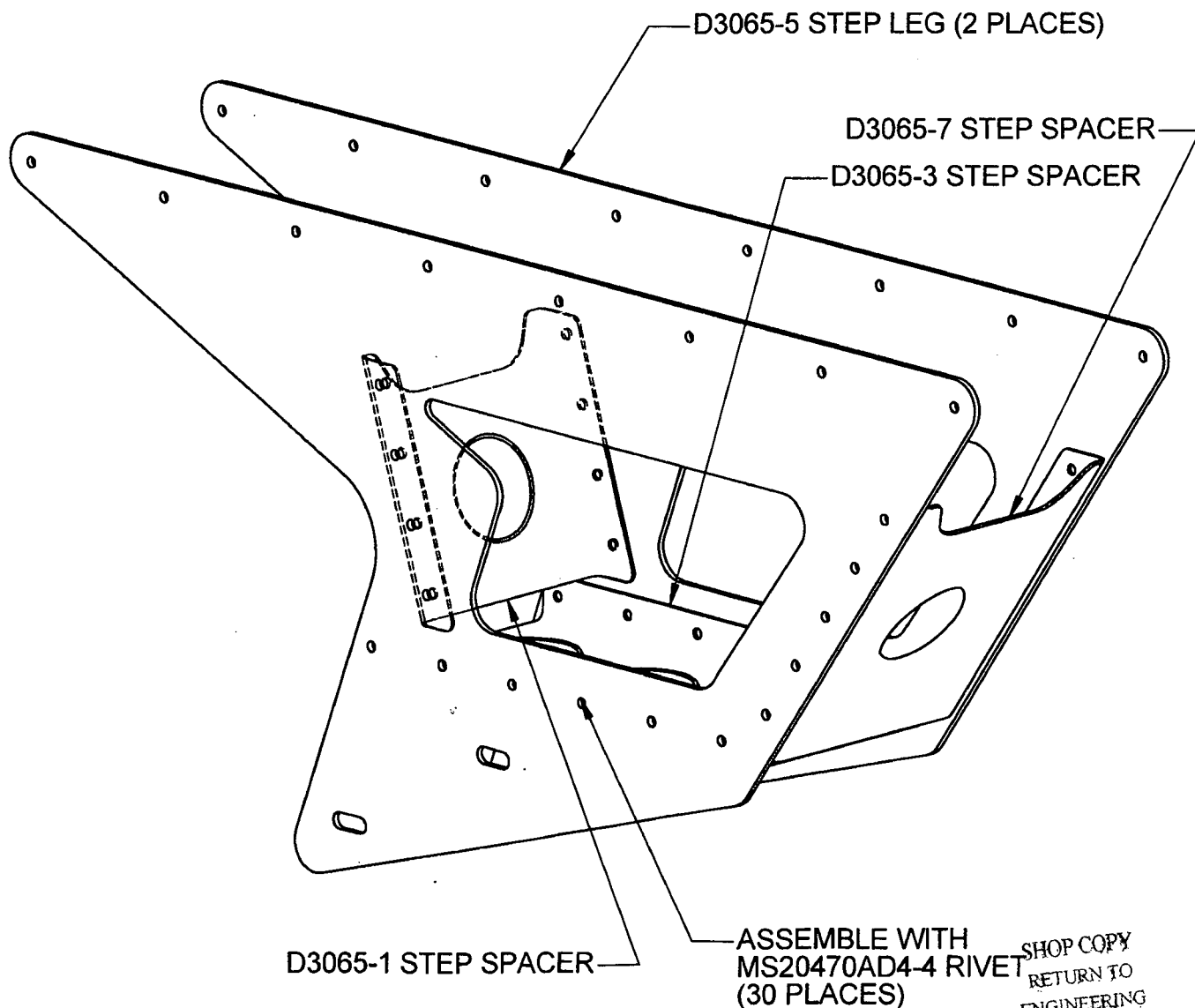
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY SCALE 1:2	
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

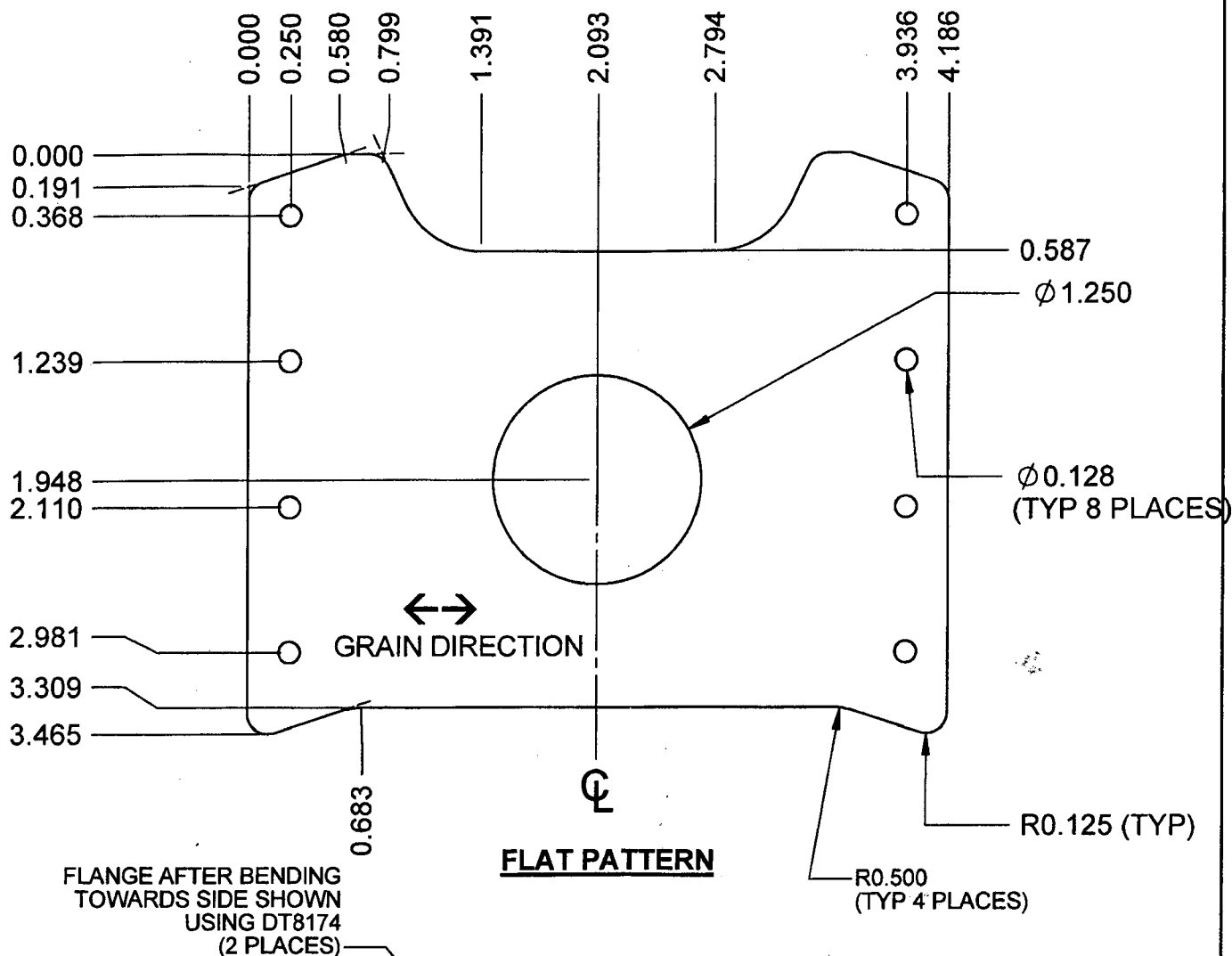
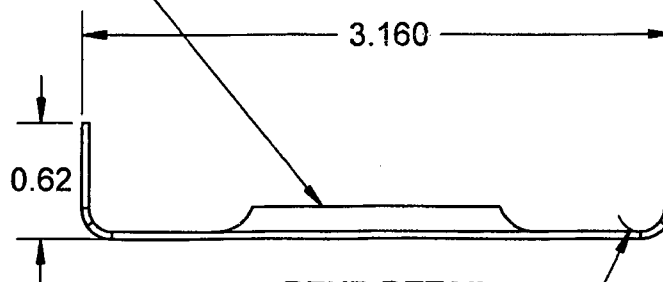
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY SCALE 1:1		

**RELEASED***cl. de-20***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

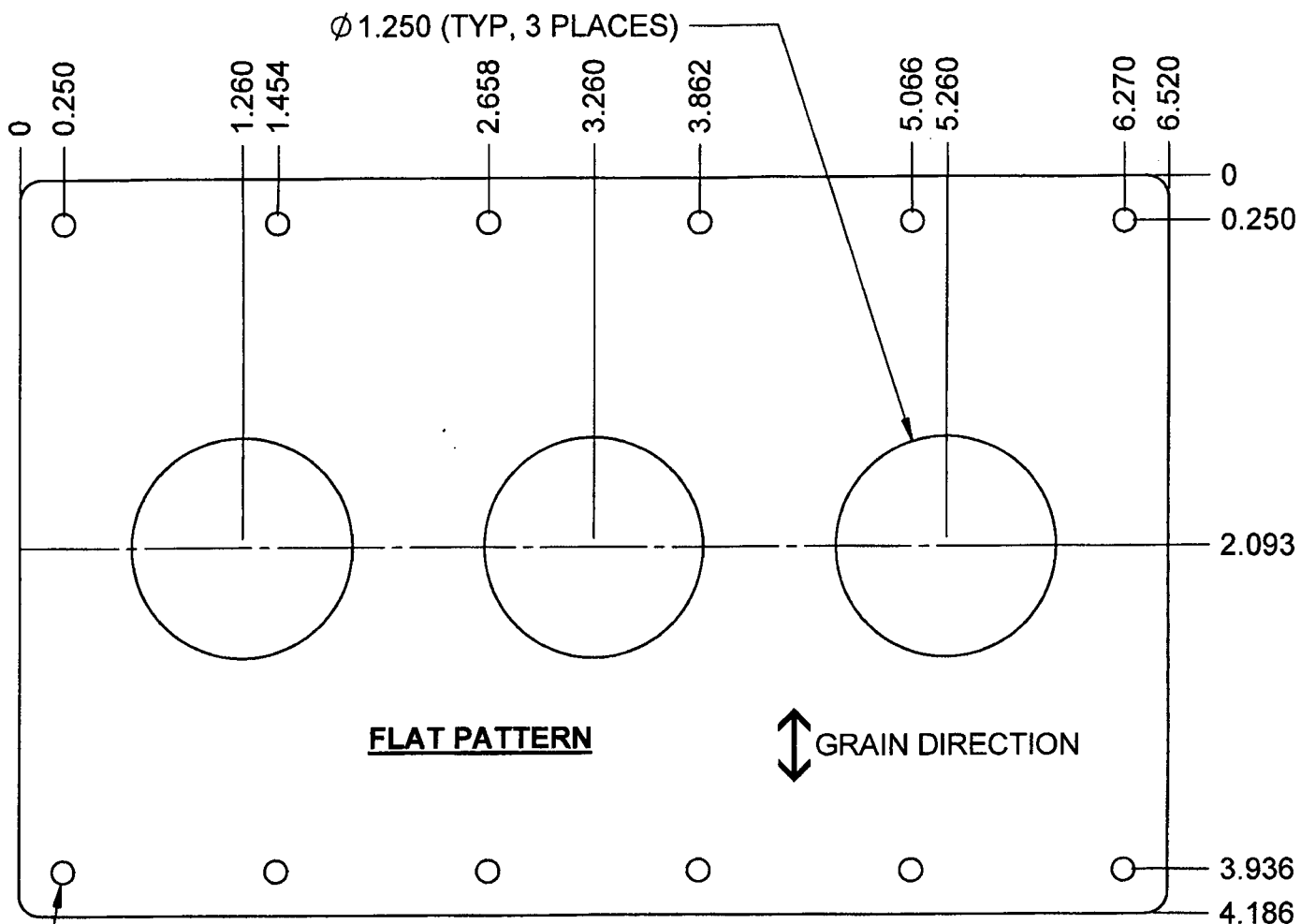
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

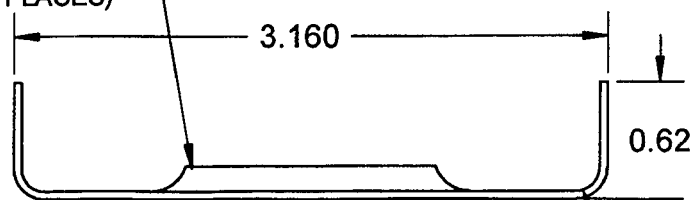


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.05.20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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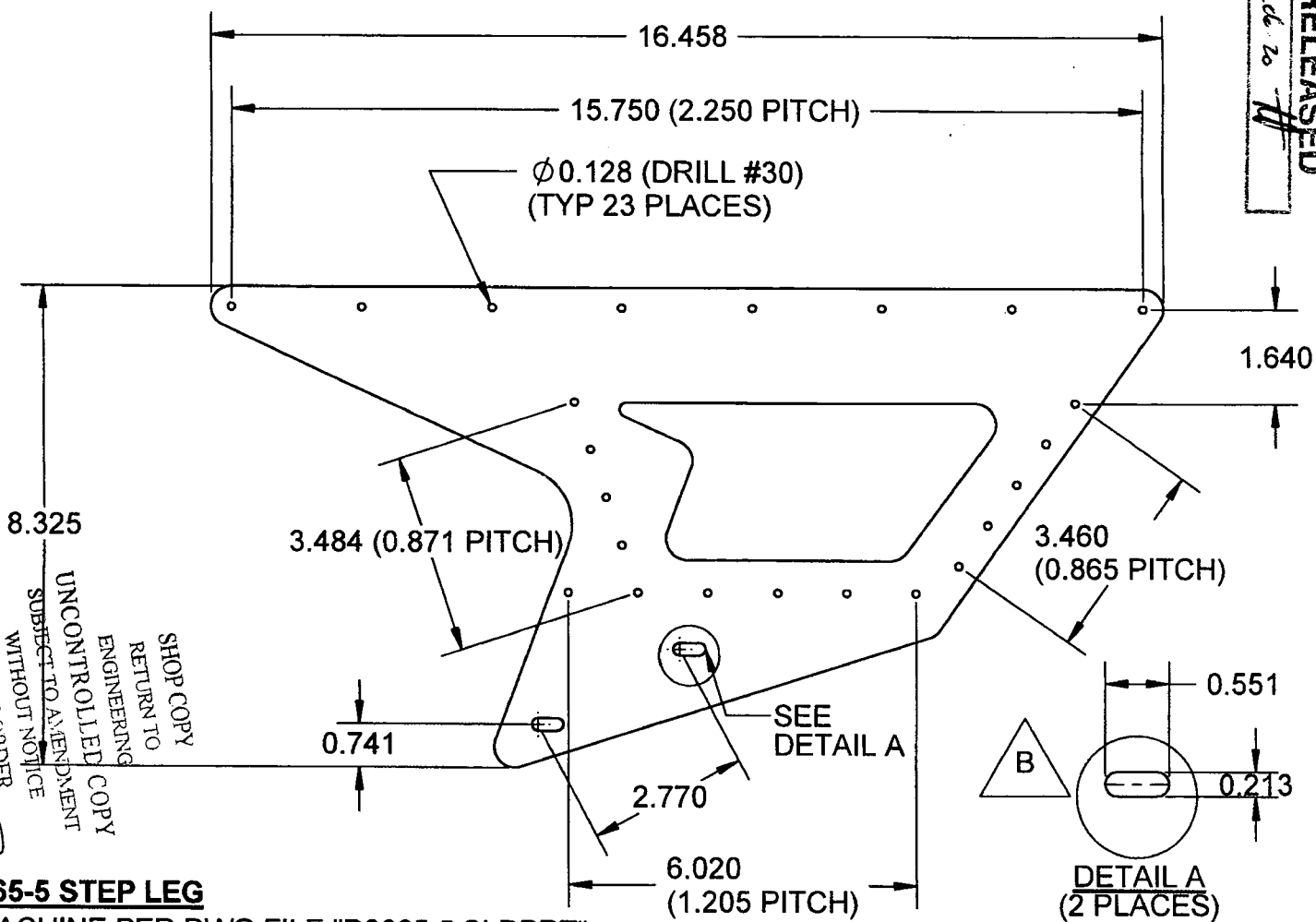
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PH		D3065
DATE		TITLE
06.05.23		STEP LEG ASSEMBLY
		SCALE
		1:3
		REV. B
		SHEET 4 OF 5

RELEASED
06.06.20



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

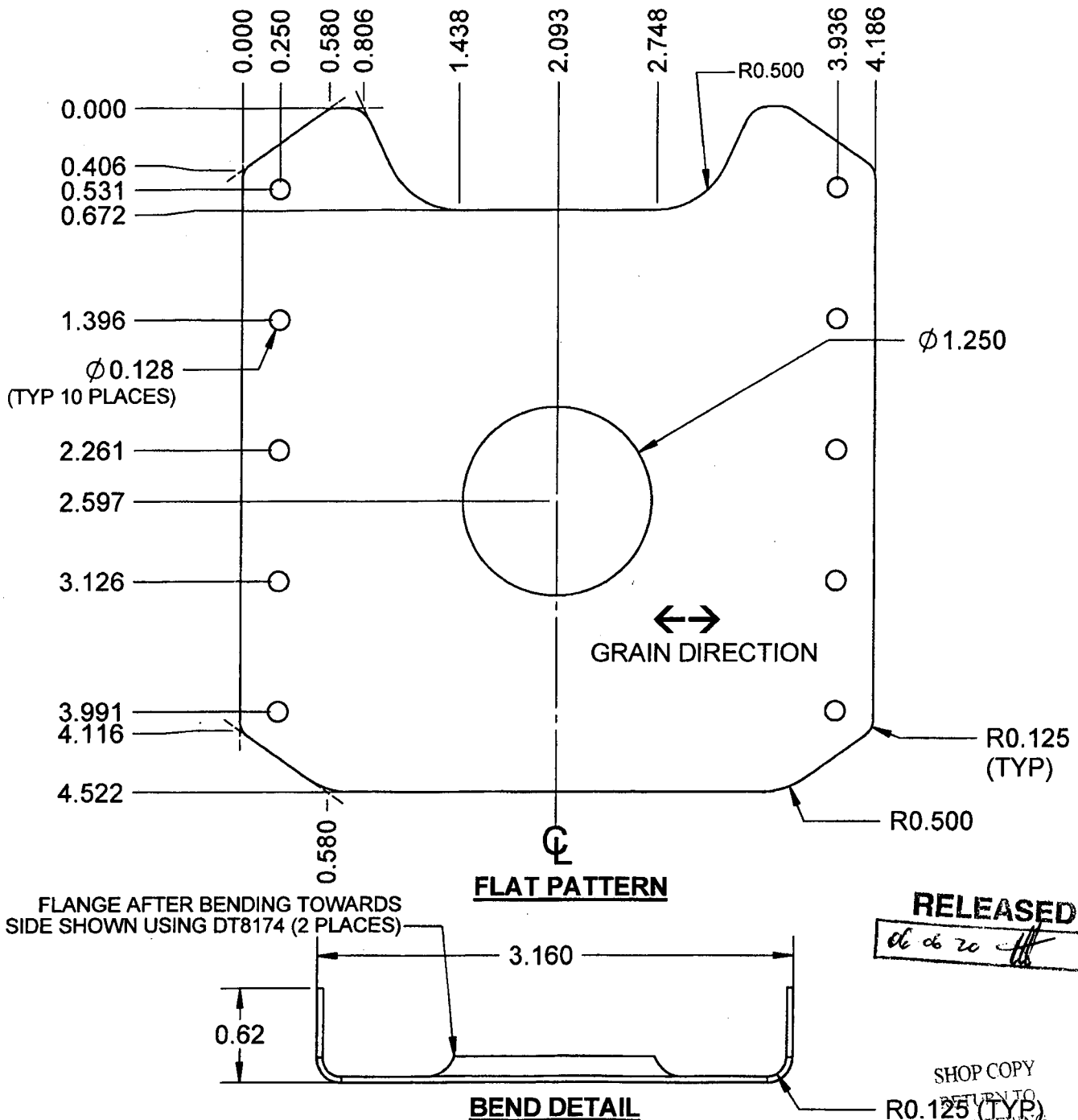
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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